

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029932**Date Inspected:** 22-Aug-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bernie Docena, Jesse Cayabyab**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Tower**Summary of Items Observed:**

Caltrans Quality Assurance Inspector (QA) Joe Adame arrived at the American Bridge/Fluor (ABF) JV job site between the times noted above in order to monitor ABF Quality Control functions and the in process work being performed by ABF production personnel. The following items were observed:

ESW Repair excavation

RWR-201308-004

ESW S-043, Location "T"- B:

The QA Inspector was later present to observe ABF welder Mike Jimenez (WID-4671) performing Shield Metal Arc Welding (SMAW) of the repair excavation on Electroslag Weld (ESW) "T", at face B. Locations are listed as detailed in Request for Weld Repair (RWR) 201308-004 from Ultrasonic Testing indications designated for repair.

The repair locations were noted as:

Y= 3000mm~3360mm

L= 360mm

W= 80mm

D= 72mm

Prior to welding, Welder -4671 was observed preheating the weld to over 300° Fahrenheit prior to welding using the Miller ProHeat 35 with heat induction blankets. The welder was using 4.0mm diameter electrode (E7018-1 HR4) per ABF Welding Procedure Specification (WPS) ABF-WPS-D15-1000-Repair Rev.3. The welding parameters were verified by QC Inspector Bernie Docena with a Fluke 337 current clampmeter and preheat was verified with temperature indicators. Mr. Docena performed welding parameters verifications at random intervals throughout the shift. The welding repair is approximately 20% complete at this location. The welding observed

WELDING INSPECTION REPORT

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appeared to be in compliance with the WPS noted above.

ESW Repair excavation

RWR-201308-003

ESW E-043, Location "Q"-Face A:

The QA Inspector observed ABF welder Donald Plumb (WID-0891) performing excavation of ESW "Q" Face A @ Y-3980mm to verify indications observed during Ultrasonic Testing pulse/echo & pitch/catch. Mr. Plumb was performing the excavation using an air carbon arc gouging and a grinder. The repair previously commenced on 8-21-13. Location of the repair excavation is as follows:

Weld excavated at 74mm dp- No indications observed.

Final excavation: Y=3800mm~4300mm, L=500mm, W=80mm, D=70mm

After grinding to bright metal the ABF QC Inspector Bernie Docena performed MT testing of the excavation. The QC Inspector stated the excavation appears to be free of discontinuities and he would complete ABF daily inspection report and magnetic particle testing report to detail the findings. The QA Inspector also performed MT inspection of the final excavation. After excavation Mr. Plumb was observed setting up to perform SMAW repair welding on this date. See TL-6028 for additional details on items inspected on this date.



Summary of Conversations:

Only general conversations with ABF/JV QC NDT personnel relevant to work and testing performed during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Adame,Joe	Quality Assurance Inspector
Reviewed By:	Mertz,Robert	QA Reviewer
